



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D5320-5
Job Sheet 179331



Part No: D5320-5

Job Qty: 70 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 15-10-13 JLM VERIFIED BY:DD IPP REV:B 16.03.28 AS PER DWG
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	70 Ea		8/31/18	0.00	0.00	Start Up Waterjet		DL 18/06/22
100	Waterjet	70 pcs		8/31/18	0.00	3.58	Waterjet1		DL 18/06/22
117	QC	70 pcs		8/31/18	0.00	0.00	QC8		38
118	Brake NC	70 pcs		8/31/18	0.00	5.87	Brake NC 1		9-89
120	QC	70 pcs		8/31/18	0.00	0.00	QC5		
130	Packaging	70 pcs		8/31/18	0.00	0.00	Packaging3		JUL 30 2018
140	QC21-SA	70 Ea		8/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D5320 2-Break edges
Descriptions: 118 - FORM AS PER DWG USING DT10190

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S12GA	304/316 0.100" Sheet	1.7150 sf (.0245 ea)	90-Start up Operation	304 8/16/18 5068420

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S12GA	2	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.453Inches ± 0.005	0.458 0.448	Diameter	
2	Bracket	0.600Inches ± 0.030	0.630 0.570		
3	Bracket	1.200Inches ± 0.030	1.230 1.170		
4	Bracket	1.800Inches ± 0.010	1.810 1.790		
5	Bracket	2.800Inches ± 0.030	2.830 2.770		
6	Bracket	0.109Inches ± 0.010	0.119 0.099		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Moved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____		Qty Effective : _____		MRB (QSI042) Approval																																																																																	
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		Completed By																																																																																			
		Lead hand / Supervisor Approval Verification																																																																																			
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Work Order: <u>179331</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D5320-5</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☒	Engineering ☐		
NCR No.		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date: <u>18-07-26</u>	Step #: <u>100</u>	QTY Effective: <u>70</u>	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	PD 18-07-26
M304S11GA was use instead of M304S12GA.	Scrap destroy no replace material pull S043440/S068420 is also M304S11GA.	Completed By PD 18/08/16
		Lead hand / Supervisor Approval Verification PD 18-07-27
		QC / QA Coordinator Approval PD 18-07-27

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☒	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	☒ Wrong Stock Pulled	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					